

Date: Friday, 01/08/2008 10:42:24 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RAPPEL ANCHOR
Job Number : 40891	
Estimate Number : 11069	
P.O. Number :	Part Number : D2224
This Issue : 01/08/2008 S.O. No. :	Drawing Number : D2224 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 37744	Material :
Written By :	Due Date : 29/08/2008 Qty: 10 Um: Each
Checked & Approved By : JLD 08.8.05	
Comment : Est Rev:D 02.04.23 Add note for grain direction & inspect 8, 21 N G	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M7075T73B2500X0325	7075-T73 Bar 2.50 x 3.25
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Comment: Qty.: 0.2321 f(s)/Unit Total : 1.1603 f(s)
 7075-T73 Bar 2.5 x 3.25"
 (M7075T7B0325X0320)
 Batch: M 1410 102694

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 2.660" +.030" / -.010"
 *****Note grain direction *****

SA 08/08/06

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio D2224 & Dwg D2224

2-Deburr & Tumble

SA/DJP 08/08/07

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA/DJP 08/08/07

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

N.A/P.R. 08/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:42:24 AM
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Drawing Name: RAPPEL ANCHOR

Job Number: 40891

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0 OUTSIDE SERV.30 OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES
Issue P/O: 6956
Red Anodize as per Dwg D2224 MIL-A-8625

C208/08/15 (10)

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Recieve & Inspect for Transit Damage

Puff 28 (10)

Revised
check

8.0 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ANODIZE

S 02/08/09

(PTC)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST21

Puff 28 (10)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/03

Job Completion



MF 08-09-03

W/O: 40891

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.08.29	8.0	REPLACE QC 3 WITH QC 5 PERMANENT CHANGE (ESTIMATE 11069)	[Signature]	08.09.04		[Signature] 08.09.04	S 08.09.04

Part No: D2224 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

H:\FORMS\Quality Assurance\approved QA\NCRWQ RevD

DART AEROSPACE LTD		Work Order: 40891
Description: Rappel Anchor		Part Number: D2224
Inspection Dwg: D2224	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.188	+/-0.010	.186	/			
0.050 x 45°	+/-0.010 x 0.5°	.050 x 45°	/			
0.250	+/-0.010	.250	/			
R0.500	+/-0.010	R.500	/			
3.000	+/-0.010	3.001	/			
Ø0.507	+0.008/-0.001	Ø.506	/			
0.750	+/-0.010	.749	/			Cannot measure accurately
2.313	+/-0.010	2.314	/			
1.687	+/-0.010	1.687	/			
2.438	+/-0.010	2.440	/			
1.125	+/-0.010	1.125	/			
Ø0.313	+0.006/-0.001	Ø.313	/			

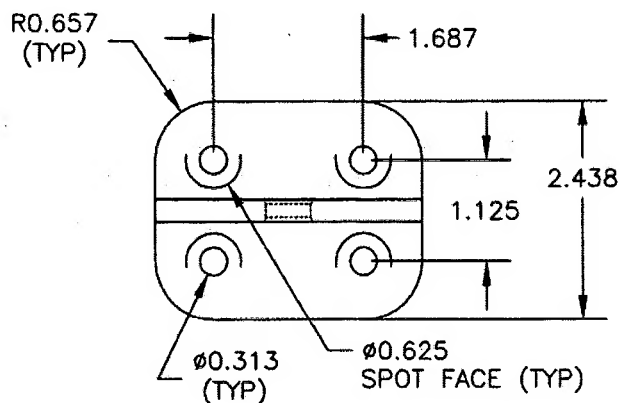
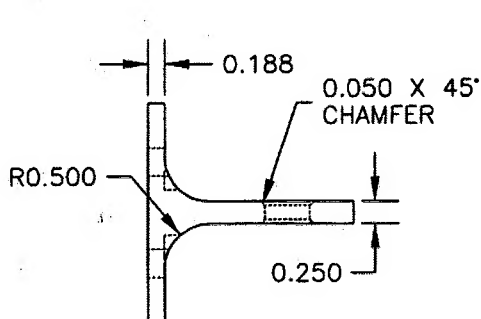
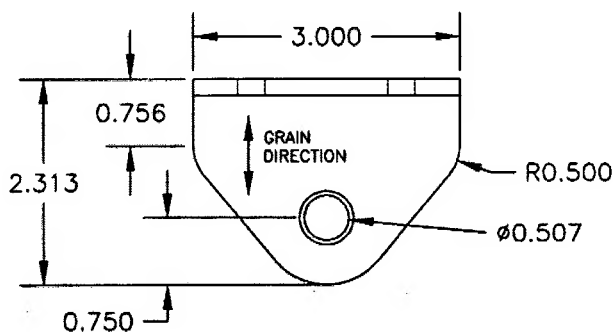
Measured by: S. J. D. P.	Audited by: M. A. P. A.	Prototype Approval:	N/A
Date: 08/08/06	Date: 08/08/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	



RELEASED
99.05.11 KE

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2224	REV. E SHEET 1 OF 1
DATE 99.04.29		TITLE RAPPEL ANCHOR	SCALE 1:2
A	94.03.10	NEW ISSUE	
B	95.04.11	D2227 WAS D2216	
C	96.06.17	ADDED D2224-60	
D	97.04.25	CHANGE TO T-SHAPE	
E	99.04.29	REVISE MATERIAL SPECIFICATIONS	



MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)
FINISH : ANODIZE RED PER MIL-A-8625
BREAK ALL UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40891

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified
approuvé NADCAP approved

67430

25-Aug-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****NO. DE COMMANDE:
PURCHASE ORDER/ 6956**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	7	7	D2091 B30137 -	-
2	8	8	D2000-047 B35293 -	BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2
3	10	10	D2224 B40891 -	BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2
				BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2

S
02/08/09

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient

Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air

ambiant.

Signature/Signed: 
☐ Directeur de la Qualité / Q.A. Manager